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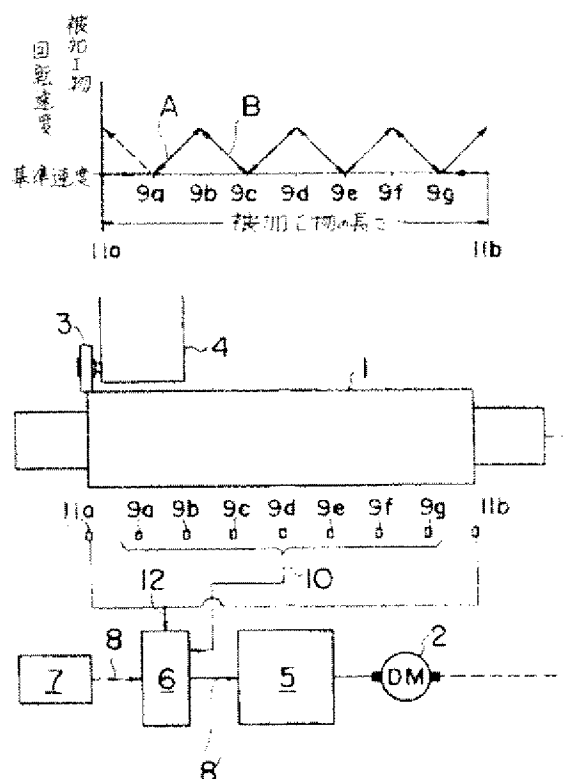
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APPLICANT : TOSHIBA MACH CO LTD;

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TITLE : AUTOMATIC GRINDER FOR ROLLING MILLS



ABSTRACT : PURPOSE: To obtain an automatic grinder for rolling mills, which minimizes the influence of chattering by automatically increasing or decreasing gradually the rotating speed of a work in accordance with the traverse of a grindstone, the rotation of the work, or working time.

CONSTITUTION: The standard rotating speed of a work 1 is set on a standard rotating speed section 7. When an end sensor 11a is actuated, a function generator 6 is reset so that the rate of increase and decrease becomes zero and the work 1 rotates at the standard rotating speed when the grindstone starts its traversing motion. When the grindstone moves from the left end to the right and sensors 9a-9g are actuated, the function generator 6 goes into action to increase or decrease the speed command signal 8 from the standard rotating speed setting 7, thus controlling the rotating speed of the work. This minimizes the influence of chattering if it occurs during the grinding operation.

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